

Work Order ID 82949

82949

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Wednesday, April 11, 2012 2:53:44 PM

Item ID: D2873-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Nut Plate Assembly
 Start Date: 4/11/2012 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 4/25/2012 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: P Date: 12/04/14 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2873	Rev A								

100 0.00
100 BAND SAW
 Bandsaw Memo 0.00 FK 12/04/14 40 8
 Jeaspa Bandsaw Cut blanks: 1.000" x 0.375" x 3.700" long

110 0.00
110 HAAS CNC VERTICAL MACHINING #1
 HAAS I Memo 0.00 cmk 12/04/14 40 8
 HAAS CNC vertical machine #1 Machine as per Folio FA and Dwg D2873 Identify as D2873-3
 Dwg Rev A Folio Rev AA

120 0.00
120 QC2- Inspect parts off machine FAI/FAIB
 QC Memo 0.00 cmk 12/04/14 40 8
 Quality Control

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	SL	12/04/20					
140 *140* Small Fab Small Fab	Small Fab Memo 1-Deburr 2- C'sink as per Dwg D2873	0.00 0.00				40	0		SP 12/04/23
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		5/26/23		cont +40			

Dart Aerospace Ltd

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 Required Date: 4/25/2012 Req'd Qty: 20.00 *20* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Chemical Conversion Coat per QSI005 4.1	0.00							
160									
HandFinish	Memo	0.00							
Hand Finishing									
170	QC3- Inspect Part Finish	0.00							
170									
QC	Memo	0.00							
Quality Control									
180		0.00							
180	Small Fab								
Small Fab	Memo	0.00							
Small Fab	1-Assemble as per Dwg D2873 2-Identify as D2873-043								

40 26 12-4-23

40 0 12-4-24

40 0 12/04/24

W/O:		WORK ORDER CHANGES					
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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		5/16/25		140			
200 *200* Packaging Packaging	Identify as per dwg & Stock Location: <u>LG52</u> Memo	0.00 0.00							12-4-25 (40)
210 *210* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							12/4/25 [Signature] D12-0425

Dart Aerospace Ltd

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NOTE: Date & initial all entries

Picklist Print

Wednesday, April 11, 2012 2:53:49 PM

Page 1

Work Order ID: 82949

82949

Parent Item: D2873-043

D2873-043

Parent Item Name: Nut Plate Assembly

Start Date: 4/11/2012

Required Date: 4/25/2012

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP A05.09.13New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MS21075L5

Purchased

No

100

Each

26.0000

3

60

MS21075L5

Nut Plate

**

PS 12/04/24

Location

Loc Qty

Loc Code

ST304

26

121162

26

26

M12/444 (94)

M6061T6B0.375X01.00
0

Purchased

No

180

f

35.8120

0.3083

6.490526

M6061T6B0.375X01.000

6061T6 BAR .375 x 1.00

**

FK 12/04/14

Location

Loc Qty

Loc Code

MAT001

2.292

118641

2.292

MAT002

33.52

119346

12

120603

0.76

120866

0.76

121192

20

12

99

MS20426AD4-6

Purchased

No

180

Each

1,514.000

6

120

MS20426AD4-6

Rivet

**

PS 12/04/24

Location

Loc Qty

Loc Code

ST317

1514

110139

187

118510

653

119436

674

240

Dart Aerospace Ltd

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	82949
Description: Radius Block		Part Number:	D2873-3
Inspection Dwg: D2873 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST



☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.50	+/-0.030	3.501	—		Ucrn 11-06	
2.000	+/-0.010	2.000	—			
0.750	+/-0.010	.750	—			
1.000	+/-0.010	1.000	—			
0.250	+/-0.010	.250	—			
1.000	+/-0.010	1.000	—			
2.000	+/-0.010	2.000	—			
3.000	+/-0.010	3.000	—			
Ø0.128	+0.005/-0.001	Ø.130	—			
0.359	+/-0.010	.359	—			
Ø0.316	+0.006/-0.001	Ø.317	—			
1.000	+/-0.010	1.010	—			
0.250	+/-0.010	.248	—			
0.061	+/-0.010	.061	—			
Ø0.230 x 0.125	+0.005/-0.001 x 0.010	Ø.230 x .128	—			

Measured by:	comf
Date:	12/04/19

Audited by:	SL
Date:	12/04/20

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.08.30	New Issue P/O D2873-043	KJ/JLM	 

Dart Aerospace Ltd

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NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING

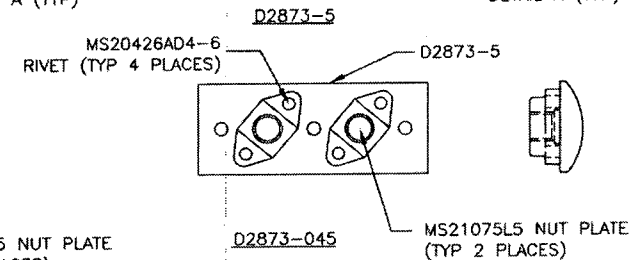
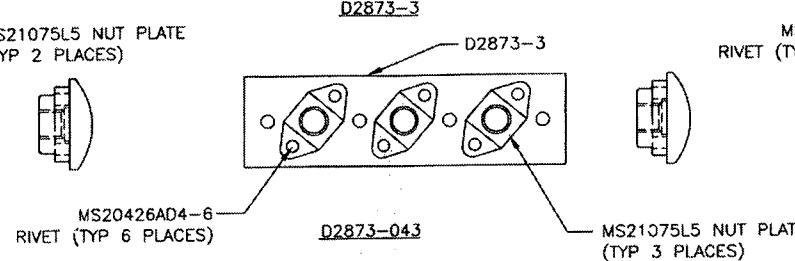
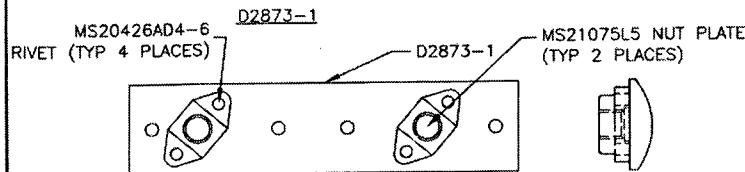
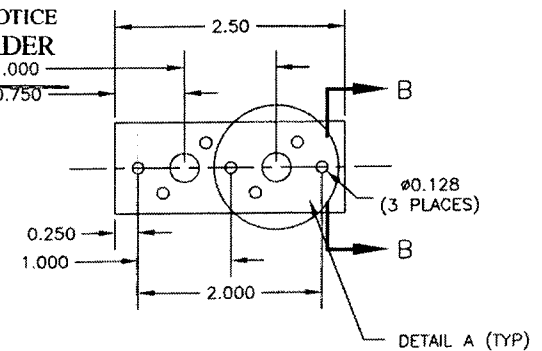
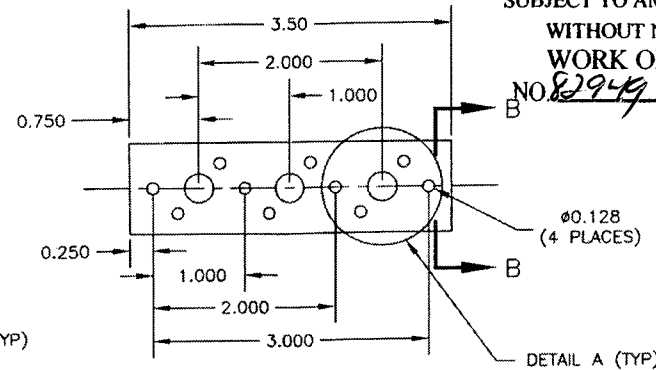
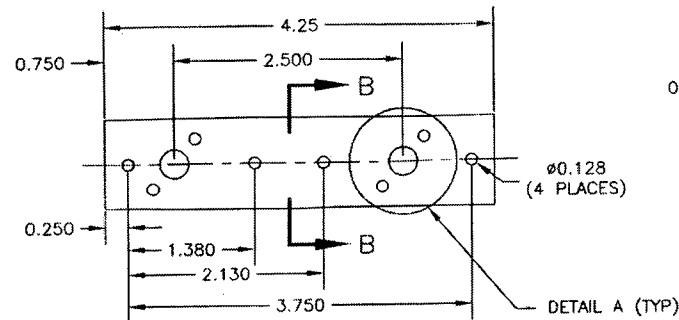
12-04-7

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO 82949



D2873-041

D2873-043

D2873-045

D2873-1/-3/-5 RADIUS BLOCK

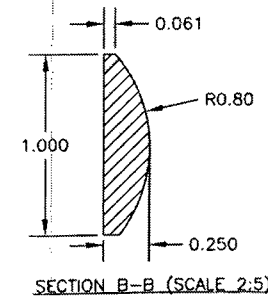
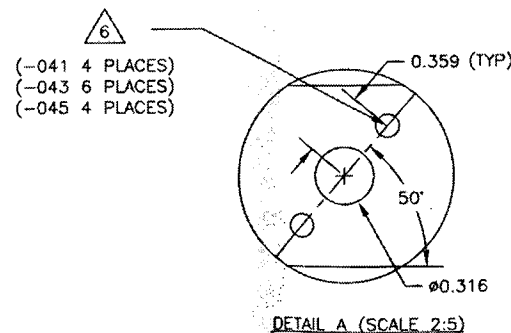
- 1) MATERIAL: 5052-H32/H34 BAR (QQ-A-225/7) (REF. DART SPEC M5052H32B1.000X0.250) OR 6061-T6 BAR (QQ-A-225/8 OR QQ-A-200/8) (REF. DART SPEC M6061T6B1.000X0.250)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 6) Ø0.128 PILOT + C'BORE CURVED SIDE Ø0.230X0.125 DEEP + C'SINK CURVED SIDE Ø0.225 x 100'

D2873-041/-043/-045 NUT PLATE ASSEMBLY

- 1) INSTALL MS21075L5 NUT PLATE IN ORIENTATION SHOWN USING MS20426AD4-6 RIVETS

D2873-041/-043/-045 NUT PLATE ASSEMBLY PARTS LIST

	-041	-043	-045	PART NUMBER	DESCRIPTION
X				D2873-041	NUT PLATE ASSEMBLY
	X			D2873-043	NUT PLATE ASSEMBLY
		X		D2873-045	NUT PLATE ASSEMBLY
1				D2873-1	RADIUS BLOCK
		1		D2873-3	RADIUS BLOCK
			1	D2873-5	RADIUS BLOCK
4	6	4		MS20426AD4-6	RIVET
2	3	2		MS21075L5	NUT PLATE



RELEASED
05-07-26

A	05.07.26	NEW ISSUE
DESIGN	PH	DRAWN BY PH
CHECKED DS	APPROVED DS	DRAWING NO. D2873
DATE 05.07.26	TITLE RADIUS BLOCK	REV. A SHEET 1 OF 1 SCALE 4:5

W/O:		WORK ORDER CHANGES					
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